

Work Order ID 50627

July 17, 2009 11:41:03 AM



Page 1

Item ID: D350-748-141TRN
 Revision ID: D
 Item Name: Crosstube Turning Detail
 Start Date: 7/24/09 Start Qty: 1.00
 Required Date: 8/14/09 Req'd Qty: 1.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:
 Customer:



Approvals: Process Plan: *[Signature]*
 QC:

Date: Tooling: Date:
 Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-748-141	Rev D

100	MORI SEIKI CNC LATHE LARGE	0.00							
	MORI SEIKI	0.00							
Mori Seiki CNC Lathe Large	Memo								
	1-Fill tube with sand & install plugs on both ends as per Folio FA648□2-Turn first side as per Folio FA648□3- File transition lines smooth.								

am 09-09-14①

110	QC1- Inspect dimensions to dimension sheet	0.00							
	QC	0.00							
Quality Control	Memo								

am 09-09-14①

120	MORI SEIKI CNC LATHE LARGE	0.00							
	MORI SEIKI	0.00							
Mori Seiki CNC Lathe Large	Memo								
	1-Turn second side as per Folio FA648□2- File transition lines smooth.□3- Scribe Part & Batch as per Dwg D350-748-141								

am 09-09-14①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

Am 09-09-17 ①

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

1 Ø - Awm 7-10-06

150

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Grind machining marks

1 Ø - Awm 7-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Outsource process - Heat Treat

0.00



Outsource1

Memo

0.00

Outsource process - Heat Treat

Issue P/O: 10539 ☐ Heat Treat to min 180 KSI As per Dwg D350-748-141 ☐ (MIL-T-6736 OR AMS 2759-1C) ☐ Sand Blast tube after Heat Treat ☐ Possible Supplier: Vac Aero ☐ Ensure Certificate of Conformity is attached09-10-7

170

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformaty is attached

09/14/09

180

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

0801/1270

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00



Packaging

0.00

Packaging

Memo

Packaging

Identify and stock in kanban rack ☐ Location: Back Hall

MB 09-11-23

200

0.00



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

09/11/24 AD
MF 09-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 17, 2009 11:41:02 AM

Page 1

Work Order ID: 50627

Parent Item: D350-748-141TRNRevD

Parent Item Name: Crosstube Turning Detail

Comments:

Start Date: 7/24/09

Required Date: 8/14/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6017-115RevA		Manufactured	No			110	Each	42.0000	1.0000			



Crosstube Material

G-m 09-07-14 ①

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

42

32912

42

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50627
Description: Crosstube Assembly (AS350/355 High Fwd)		Part Number: D350-748-141
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒
First Article
☐
Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.243	/		
	2.180	+0.005/-0.000	2.180	/		
	2.180	+0.005/-0.000	2.183	/		
	2.237	+0.005/-0.000	2.240	/		
	2.272	+0.005/-0.000	2.276	/		
	2.306	+0.005/-0.000	2.308	/		
	2.339	+0.005/-0.000	2.339	/		
	2.339	+0.005/-0.000	2.339	/		
	0.062	+/-0.010	0.062	/		
	4.26	+/-0.030	4.284	/		
	R0.063	+/-0.010	R0.063	/		
	R0.50	+/-0.030	R0.500	/		
SIDE B	2.240	+0.005/-0.000	2.241	/		
	2.180	+0.005/-0.000	2.180	/		
	2.180	+0.005/-0.000	2.183	/		
	2.237	+0.005/-0.000	2.240	/		
	2.272	+0.005/-0.000	2.276	/		
	2.306	+0.005/-0.000	2.308	/		
	2.339	+0.005/-0.000	2.339	/		
	2.339	+0.005/-0.000	2.339	/		
	0.062	+/-0.010	0.062	/		
	4.26	+/-0.030	4.281	/		
	R0.063	+/-0.010	R0.063	/		
	R0.50	+/-0.030	R0.500	/		
	110.27	+/-0.060	110.290	/		

Measured by: G.M	Audited by: ALM	Prototype Approval: N/A
Date: 09.09.14	Date: 9-10-06	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED

06.10.31 *HA*

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW

09.02.05
Per per #09.001

OK
09.11.24

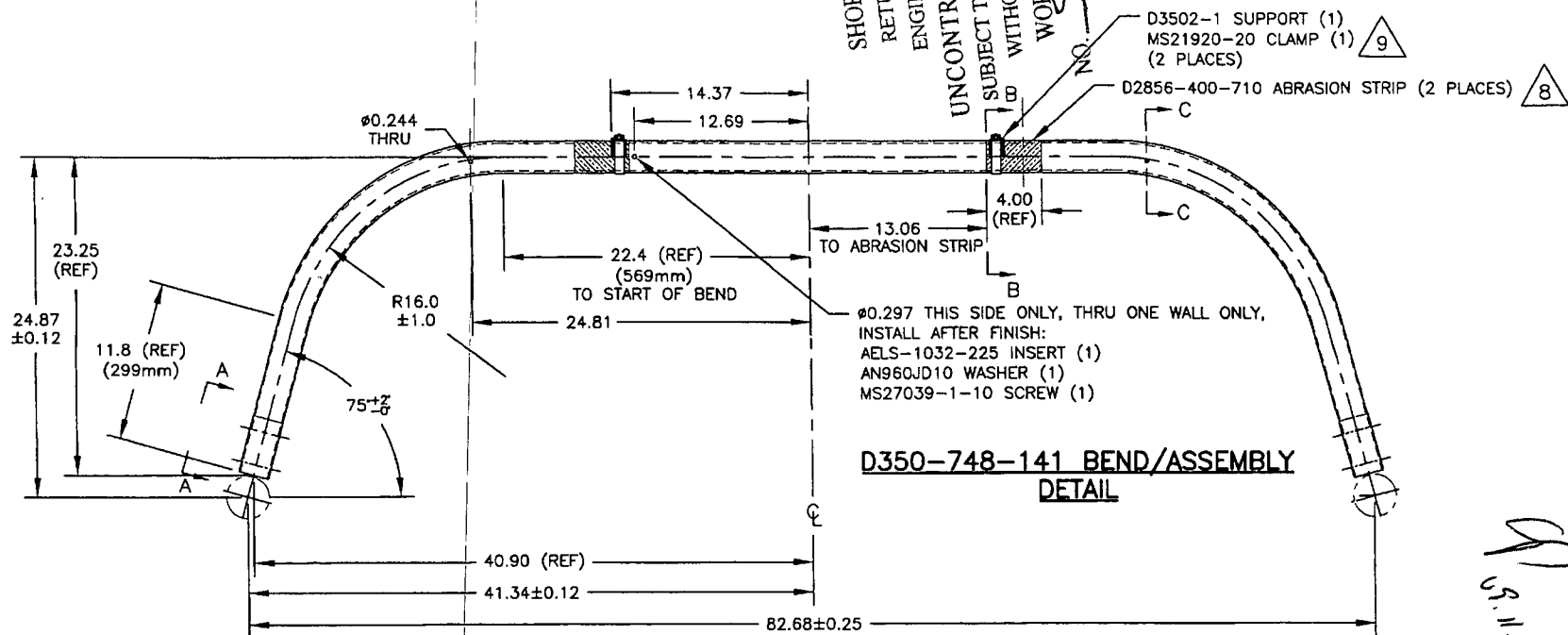
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NO. 50627

UNDER REVIEW
OK 07.10.22

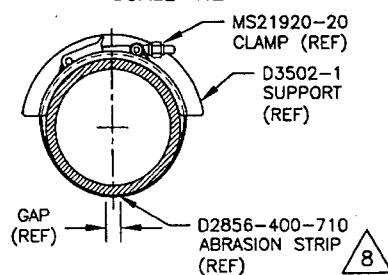
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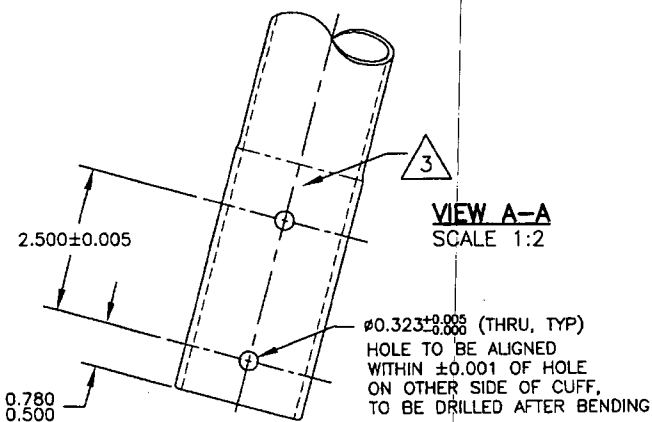
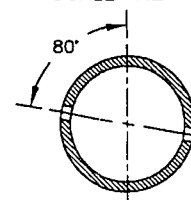
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50027



SECTION B-B
SCALE 1:2



SECTION C-C
SCALE 1:2



VIEW A-A
SCALE 1:2

OK
9.11.24

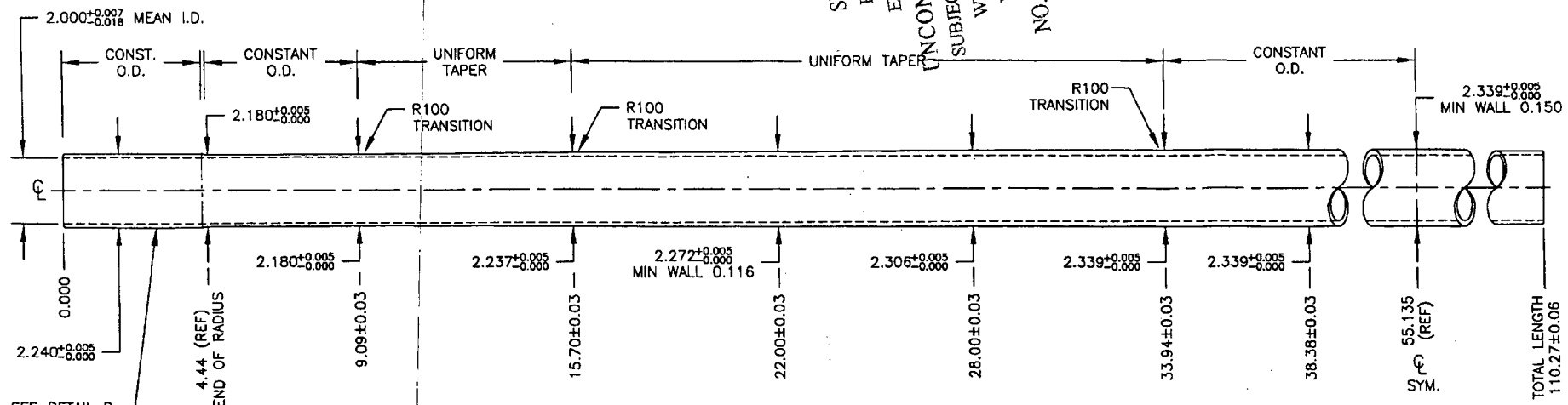
UNDER REVIEW
09.02.05

UNDER REVIEW
06.10.22

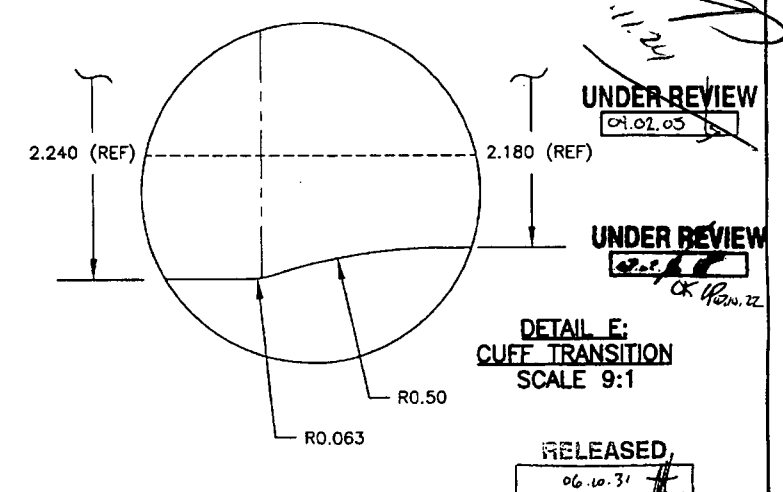
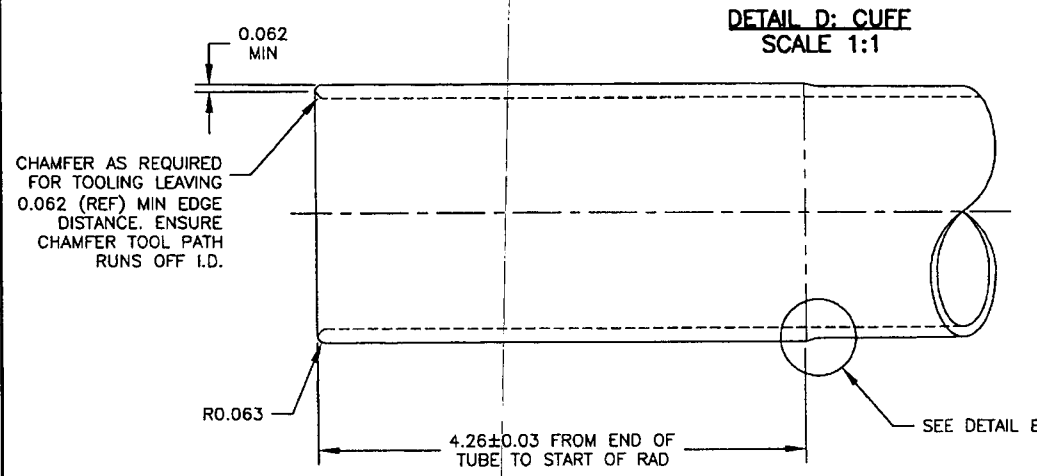
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06.10.31

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CHECKED	APPROVED	DATE	05.10.31	DRAWING NO.	D350-748-141	REV. D SHEET 2 OF 3
				TITLE	CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:8

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D350-748-141 MACHINING DETAIL



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		DATE	06.10.31	TITLE		D350-748-141	SHEET 3 OF 3
				SCALE		CROSSTUBE (AS 350/355 HI FWD)	1:3



VAC AERO
INTERNATIONAL INC.

RELEASE NO

GST No.: R105468102

OAK 113616



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6I 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

11/03/20

MM / DD / YY

PAGE: 1

1DAR01
BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/03/2009		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
10539		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141/241	EA	12	12	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO <u>180 KSI MIN.</u> PER DRAWING 100% HARDNESS CHECKED AS PER <u>ASTM E-18</u> 40/45 HRC MATERIAL: 4130</p> <p>4 PIECES B48603, B48604, B48605, B48606, P/N D350-748-241 8 PIECES B50262, <u>B50627</u>, B50628, B50629, P/N D350-748-141 B50621 <u>B50622</u>, B50623, B50625</p>					

100% HARDNESS TESTED

1.5 pc.

42/43 HRC



09.11.23

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.



METAL TREATING INSTITUTE

Laura Robinson
Authorized Q.C. Inspector



Accred
Nadca
Heat Treating • V

VACUUM BRAZING • HEAT TREATING • SPECIAL PROCESSING • FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL • PLASMA AND OTHER COATINGS